






Work Order ID 52173



Thursday, September 17, 2009 11:47:28 AM



Page 1

Item ID: D3936-1 Accept  Setup Start 
 Revision ID: A Stop 
 Item Name: Sides
 Start Date: 9/17/2009 Start Qty: 4.00  Cust Item ID:
 Required Date: 9/24/2009 Req'd Qty: 4.00  Customer:

Reference:

Approvals: Process Plan: RD NW Date: 09-9-17 Tooling: _____ Date: _____ Run Start 
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3936	A

100  0.00

Waterjet **Memo** 0.00

FLOW CNC Waterjet
 1-Cut as per Dwg D3936
 Dwg Rev: A
 Prog Rev: A
 grain direction per dwg
 2-Deburr if necessary

IB 9-9-17

(4)

110  0.00

QC **Memo** 0.00

Quality Control

IB 9-9-17

Work Order ID 52173

Thursday, September 17, 2009 11:47:28 AM

Page 2

Item ID: D3936-1

Accept

Revision ID: A

Item Name: Sides

Start Date: 9/17/2009 Start Qty: 4.00

Required Date: 9/24/2009 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

27 509/09/18

44

/

121



Small Fab

Small Fab

Memo

1- C'sink holes as per dwg

0.00

0.00

509/09/25 4

130



Brake NC

Brake NC

Memo

Bend and make joggle as per Dwg

0.00

0.00

88 09/10/06

4

/

Work Order ID 52173

Thursday, September 17, 2009 11:47:28 AM

Page 3

Item ID: D3936-1

Accept

Revision ID: A

Item Name: Sides

Start Date: 9/17/2009 Start Qty: 4.00

Required Date: 9/24/2009 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

140

QC5- Inspect part completeness to step on W/O

0.00

278 09/10/06

0.00

(FC)

4

QC

Memo

Quality Control

150

Chemical Conversion Coat per QSI005 4.1

0.00

BK 09-10-7

0.00

(H)

HandFinish

Memo

Hand Finishing

160

QC3- Inspect Part Finish

0.00

0.00

09/10/07 (4)

QC

Memo

Quality Control

Work Order ID 52173

Thursday, September 17, 2009 11:47:28 AM

Page 4

Item ID: D3936-1

Accept

Revision ID: A

Item Name: Sides

Start Date: 9/17/2009 Start Qty: 4.00

Required Date: 9/24/2009 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

170

Identify as per dwg & Stock Location: C-A

0.00



Packaging

Memo

0.00

Packaging

09/10/07 (4)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/07 HJ
MF 09-10-07

Picklist Print

Thursday, September 17, 2009 11:47:27 AM

Work Order ID: 52173



Parent Item: D3936-1RevA



Parent Item Name: Sides

Start Date: 9/17/2009

Required Date: 9/24/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No			100	sf	134.5357	11.5789			
6061-T6 .040 Sheet												

B 9-9-17

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	134.5357	
100742	3.3	
102723	7.93	
105842	12	
106747	12.5	
107461	13.1642	
109396	22.28	
111224	61.8615	
19380	1.5	

111224

DART AEROSPACE LTD		Work Order: S2173
Description: SIDES		Part Number: D3936-1
Inspection Dwg: D3936-1 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.101	*			
.300	± .010	.295	*			
1.200	± .010	1.203	*			
8.400	± .010	8.394	*			
1.200	± .010	1.198	*			
10.100	± .010	10.105	*			
.300	± .010	.295	*			
1.200	± .010	1.203	*			
2.100	± .010	2.101	*			
.700	± .010	.704	*			
4.698	± .010	4.694	*			
9.900	± .010	9.901	*			
1.100	± .010	1.102	*			
18.996	± .010	18.996	*			
2.100	± .010	2.101	*			
.700	± .010	.698	*			
23.993	± .010	23.997	*			
2.700	± .010	2.695	*			
.900	± .010	.901	*			
39.198	± .010	39.198	*			
.040	± .010	.037	*			

Measured by: IB	Audited by: S	Prototype Approval:	N/A
Date: 9-9-17	Date: 02/07/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

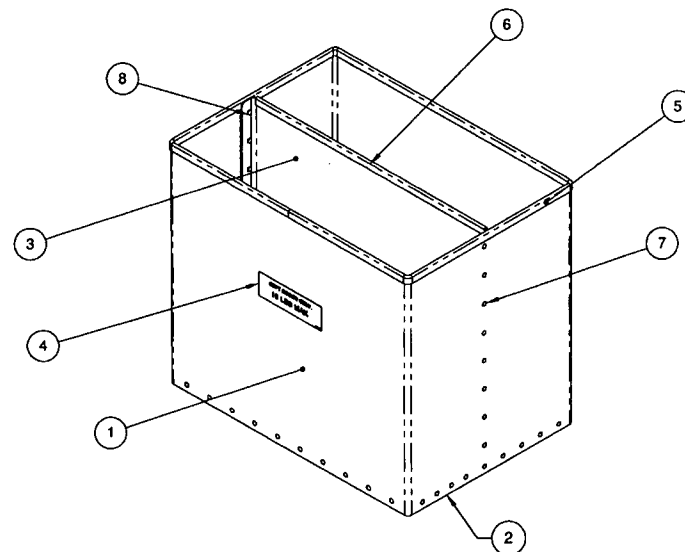
WORK ORDER

NO. 52173

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	1	D3936-1	SIDES
2	1	D3936-3	BOTTOM
3	1	D3936-5	DIVIDER
4	1	D3938-3	PLACARD
5	1	D3941-40	RUBBER CUSHION
6	1	D3941-12	RUBBER CUSHION
7	56	MS20426AD3-4	RIVET
8	8	MS20426AD3-5	RIVET

ASSEMBLY INSTRUCTIONS

- BEND D3936-1/-3/-5 PARTS PER SHEETS 2-7.
- POSITION D3936-5 DIVIDER IN PLACE INSIDE THE D3936-1 SIDES AND CLECO IN PLACE.
- POSITION THE D3936-3 BOTTOM IN PLACE AGAINST THE D3936-5 DIVIDER AND INSIDE THE D3936-1 SIDES.
- TRANSFER DRILL 10X $\phi 0.098$ (#40 DRILL) HOLES FROM THE D3936-3 BOTTOM TO THE D3936-5 DIVIDER. PLACE CLECOS IN TRANSFER DRILLED HOLES TO MAINTAIN ALIGNMENT AS THEY ARE DRILLED.
- TRANSFER DRILL 38X $\phi 0.098$ HOLES FROM D3936-1 SIDES TO D3936-3 BOTTOM. PLACE CLECOS IN TRANSFER DRILLED HOLES TO MAINTAIN ALIGNMENT AS THEY ARE DRILLED.
- REMOVE ALL CLECOS AND COUNTERSINK 64X EXTERIOR HOLES $\phi 0.179 \times 100^\circ$. DEBURR ALL HOLES IN ALL PARTS.
- REASSEMBLE PARTS USING CLECOS IN EVERY THIRD HOLE TO MAINTAIN ALIGNMENT.
- RIVET D3936-1 SIDE TO D3936-5 DIVIDER USING MS20426AD3 RIVETS. INSTALL MS20426AD3 RIVETS RANDOMLY THROUGHOUT ASSEMBLY SO THAT ALL PARTS ARE DRAWN TOGETHER EVENLY.
- RIVET D3936-5 DIVIDER TO D3936-3 BOTTOM USING MS20426AD3 RIVETS. INSTALL MS20426AD3 RIVETS RANDOMLY THROUGHOUT ASSEMBLY SO THAT ALL PARTS ARE DRAWN TOGETHER EVENLY.
- RIVET D3936-3 BOTTOM TO D3936-1 SIDE USING MS20426AD3 RIVETS. INSTALL MS20426AD3 RIVETS RANDOMLY THROUGHOUT ASSEMBLY SO THAT ALL PARTS ARE DRAWN TOGETHER EVENLY.
- POWDER COAT ASSEMBLY PER NOTE 2.
- TEST FIT RUBBER CUSHION TO TOP EDGE OF MAPBOX. TRIM AS REQUIRED FOR PROPER FIT.
- REMOVE RUBBER CUSHION.
- APPLY SMALL BEAD OF SILICONE/ADHESIVE TO TOP EDGE OF MAPBOX.
- SLIDE RUBBER CUSHION OVER EDGE AND PRESS INTO SILICONE/ADHESIVE.
- WIPE OFF ANY EXCESS SILICONE/ADHESIVE BEFORE IT DRIES/CURES.
- APPLY D3938-3 PLACARD AS SHOWN.
- ALLOW SEALANT/ADHESIVE TO CURE/DRY 24 HRS BEFORE SHIPPING PART.



D3936-041 MAPBOX ASSEMBLY

NOTES:

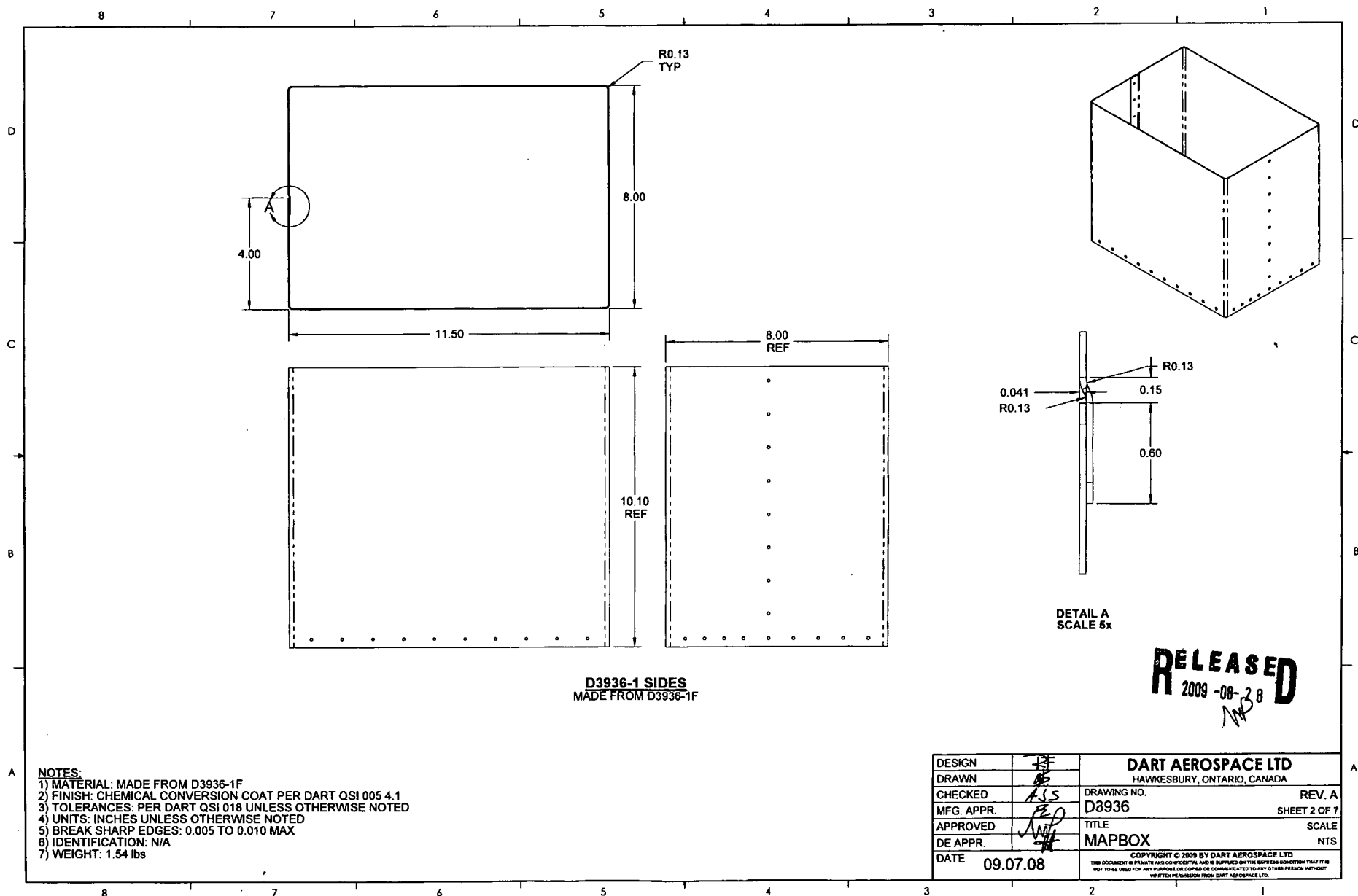
- MATERIAL: N/A
- FINISH: POWDER COAT "BLACK SANTEX" (4.3.5.7) PER DART OSI 005 4.3
- TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- IDENTIFICATION: IDENTIFY WITH DART P/N "D3936-041" AND B/N USING A WHITE FINE POINT PAINT MARKER
- WEIGHT: 2.54 lbs

RELEASED
2009-08-28

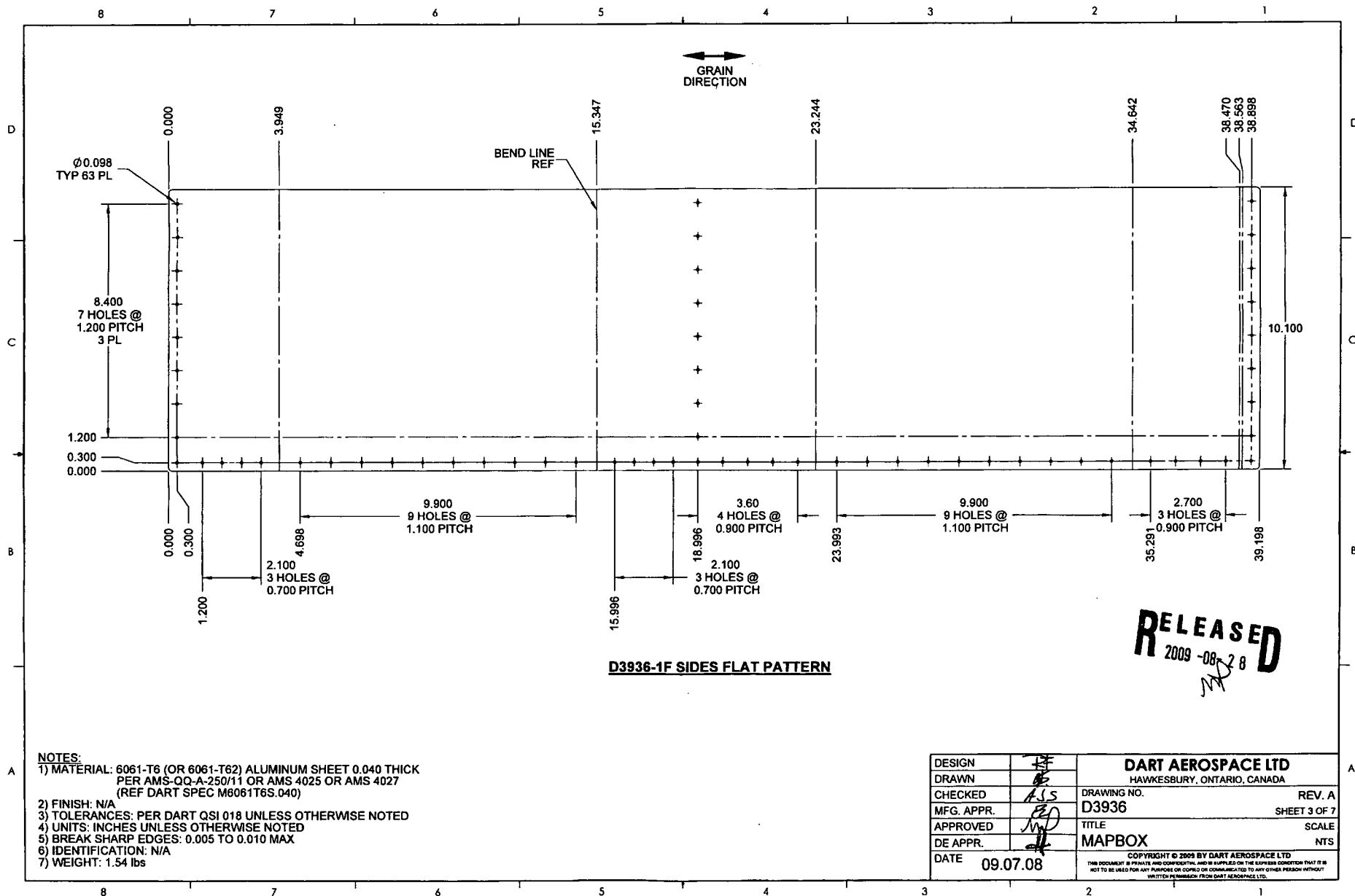
A	NEW ISSUE		09.07.08
REV.	DESCRIPTION		BY DATE
DESIGN	JS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JS		
CHECKED	JS		
MFG. APPR.	JS		
APPROVED	JS		
DE APPR.	JS		
DATE	09.07.08		

COPYRIGHT © 2009 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT	

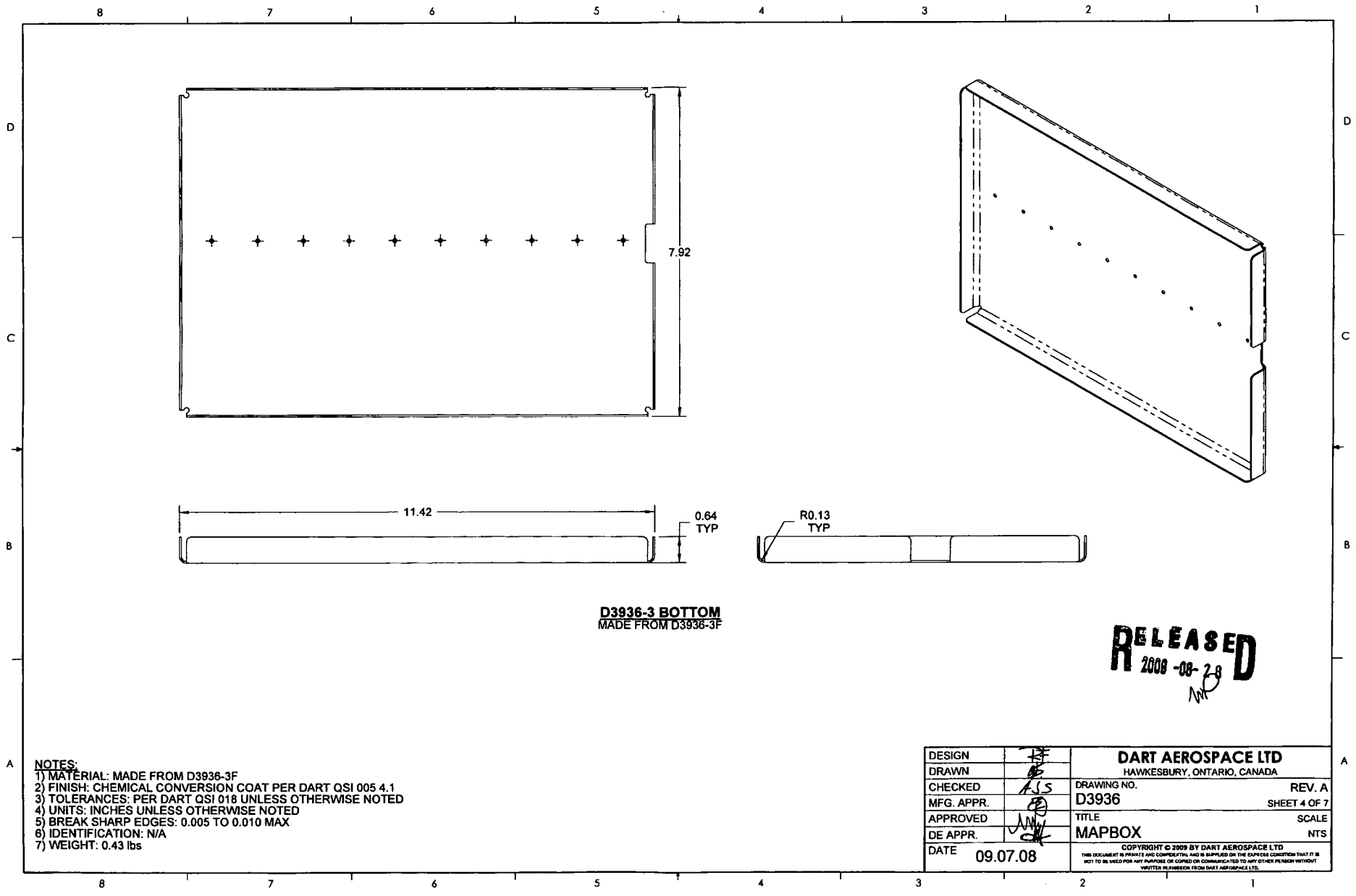
52173



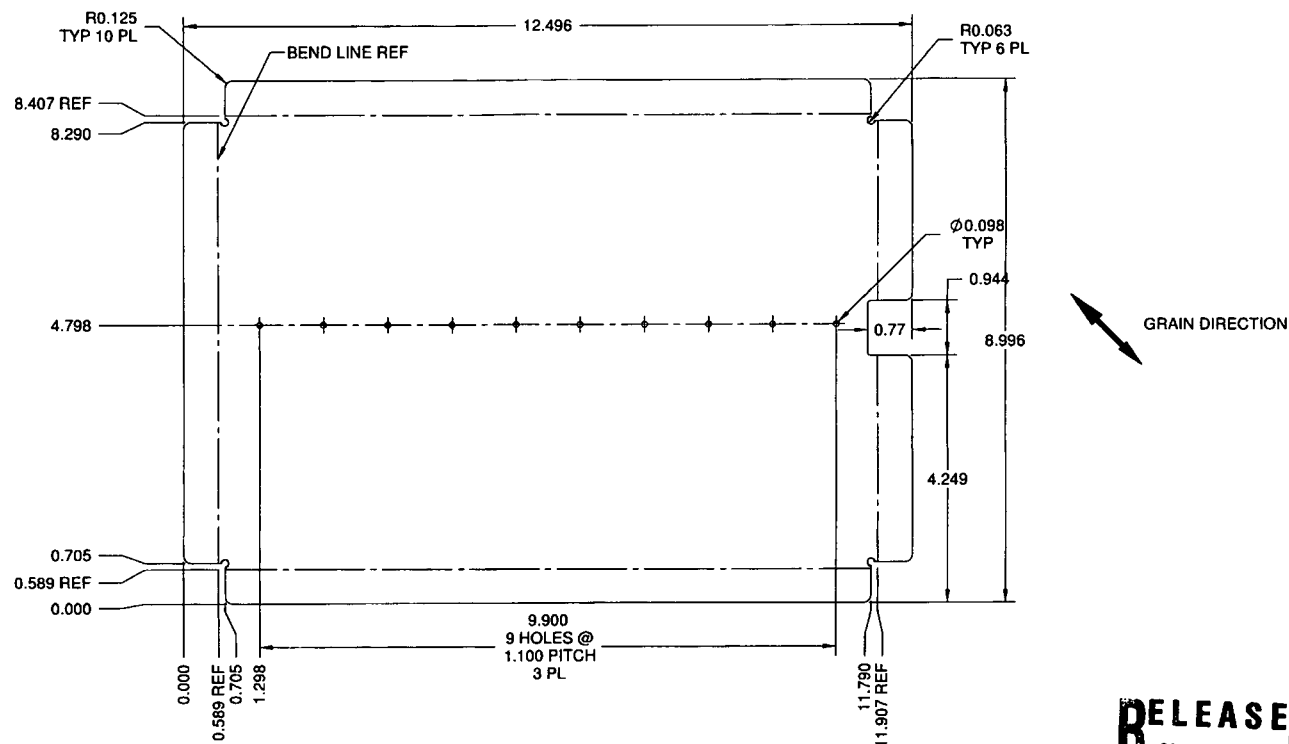
52173



52173



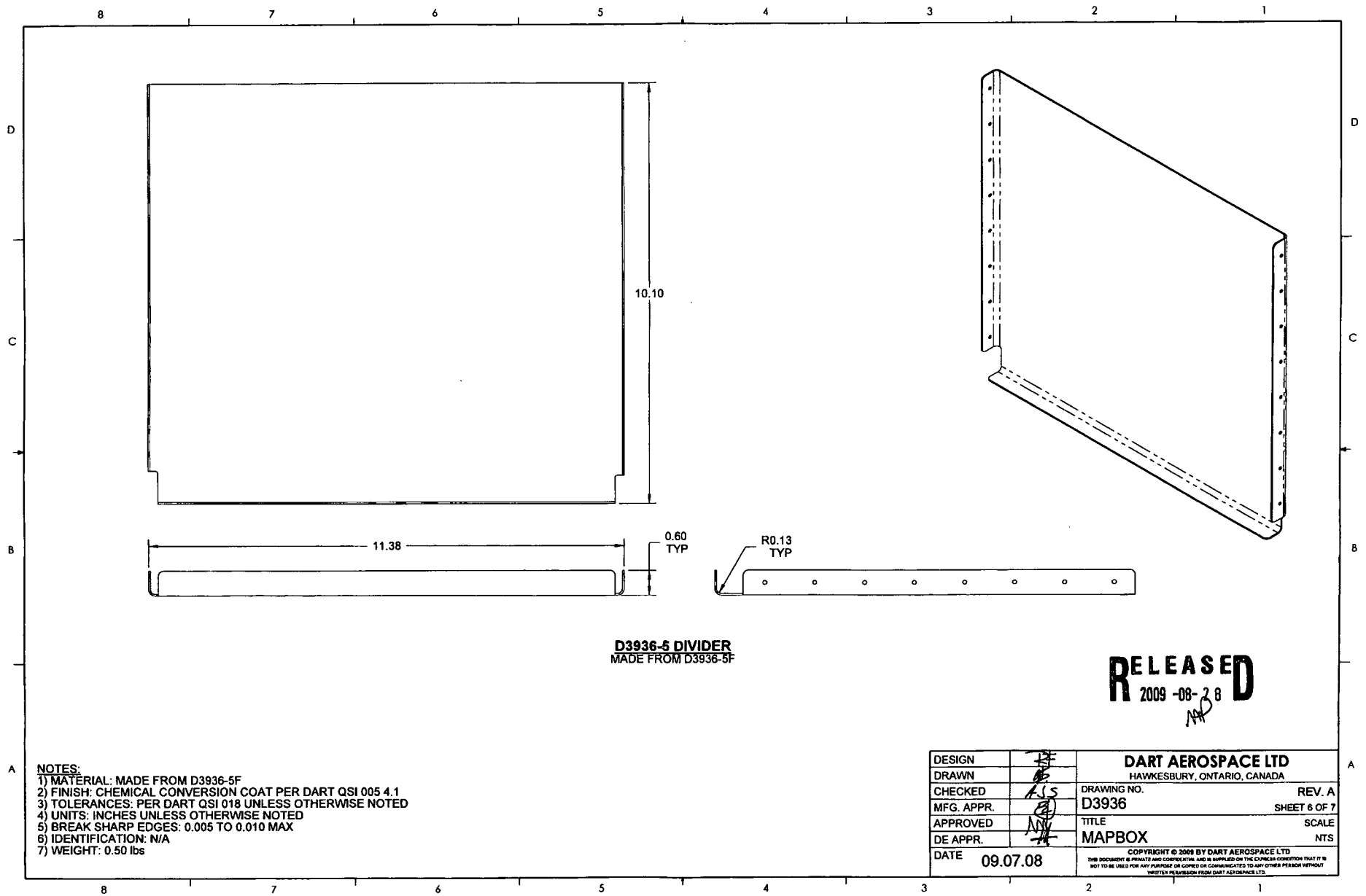
52173

**D3936-3F BOTTOM FLAT PATTERN****NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.040)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.43 lbs

DESIGN	DF	DART AEROSPACE LTD	
DRAWN	BE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.	BE	D3936	SHEET 5 OF 7
APPROVED	AD	TITLE	SCALE
DE APPR.	AD	MAPBOX	NTS
DATE	09.07.08	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

52173



D3936-5 DIVIDER
MADE FROM D3936-5F

RELEASED
2009-08-28
ND

NOTES:

- 1) MATERIAL: MADE FROM D3936-5F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.50 lbs

DESIGN	JE	DART AEROSPACE LTD	
DRAWN	JE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ALS	DRAWING NO. D3936	REV. A
MFG. APPR.	JE	SHEET 6 OF 7	
APPROVED	ND	TITLE MAPBOX	SCALE
DE APPR.	ND	NTS	
DATE	09.07.08	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

52173

